

Work Order ID 144283

144283

Page 1

April 11, 2016 3:58:07 PM

Item ID: D412-709-019 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Cargo Door Push-Out Window Clear Fits LH or RH
 Start Date: 4/12/2016 Start Qty: 2.00 ***2*** Cust Item ID:
 Required Date: 4/15/2016 Req'd Qty: 2.00 ***2*** Customer:
 Reference:

Approvals: Process Plan: SA Date: 20160411 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
N/A	Rev N/A								
100	Document Control	0.00	DAS	6					
100	DOCUMENT CONTROL		9-89			2x	DAS 28 9-89		APR 18 2016
DC	Memo	0.00							
Doc.Control -USB or Paperwork	Photocopy bluefile and create labels per PPP D412-709-019 CHG002								
110	Pick Kit	0.00							
110									
Packaging	Memo	0.00							
Packaging									
120	QC4- 100% Inspect kits for completeness	0.00							
120									
QC	Memo	0.00							
Quality Control									

ML5 16-04-12 (2)

2 APR 12 2016 DAS 6 9-89

2x DAS 28 9-89 APR 18 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : _____					

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144283

Page 2

April 11, 2016 3:58:07 PM

Item ID: D412-709-019 Accept *N900040100* Setup Start *NS1*

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Item Name: Cargo Door Push-Out Window Clear Fits LH or RH

Start Date: 4/12/2016 Start Qty: 2.00 *2* Cust Item ID:

Required Date: 4/15/2016 Req'd Qty: 2.00 *2* Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Packaging	0.00				X2			
130									
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D412-709-019 LOCATION: FG016								
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

APR 18 2016

ML5

APR 18 2016

APR 18 2016

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APR 18 2016



Work Order update only

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework Scrap Use-as-is Suspected Unapproved		AGAINST DEPARTMENT/PROCESS Skid-tube Machining Thermoforming Large Fab Cross tube Small Fab Finishing Composite Water Jet Prod. Eng. Coord. Rec/Store/Packaging Supplier Engineering Quality Other					
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval	
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause Environment Design Doc/Data Equip/Tooling Handling/Pre Material Internal Transport Tribal Knowledge LOA Substation Past Expiry Date Misidentified No Re-verification Operator Offset/Setup Supplier Training Use for Testing Poor Information Rushing Product Improvement Process Improvement Manufacturing Process Past Due		FAULT CATEGORY Pressure/Forced Bending Centre Not Concentric Cracks Crimp/Kink/Ripple/Wave Cuffs. Crushing Heat Treat Wave/Twist in Tube Marks/Chatter Temperature/Cure Set-up BOM/Route Broken/Damage/Defect Inspection Incomplete/Unqualified Contamination Countersink Cut Too Short Instructions Incomplete/Unclear Drill Holes Power Loss/Surge Folio/Program Grain Weld Wrong Stock Pulled Out of Sequence Off-set Mislabeled Fit/Function Misaligned/off center Positioned Wrong Outside Dimensions Over/Under tolerance Part Incorrect Part Lost/Missing Part Moved Drawing Finish Misread Turning Sequence							
		OTHER :							

Picklist Print

April 11, 2016 3:58:11 PM

Page 1

Work Order ID: 144283

144283

Parent Item: D412-709-019

D412-709-019

Parent Item Name: Cargo Door Push-Out Window Clear Fits LH or RH

Start Date: 4/12/2016

Required Date: 4/15/2016

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP ,A04.03.03New issueKJ/DS

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D3136-041		Manufactured	No			120	Each	7.0000	1	2			
D3136-041 Window Assembly													

Location	Loc Qty	Loc Code
ST442	7	
120086	1	
121385	2	
128359	4	

DAS 27
6 9-89

D3237-1		Manufactured	No			120	f	149.9986	8.17	16.34			
D3237-1 Seal Retainer(\$ Per Ft)													

Location	Loc Qty	Loc Code
ST420	149.9986116	
128283	45.9836837	
134740	104.014928	

DAS 27
6 9-89 DAS 27
9-89 9-89

D3237-3		Manufactured	No			120	f	148.3424	8.17	16.34			
D3237-3 Seal Filler(Price Per Ft)													

Location	Loc Qty	Loc Code
ST421	148.3424142	
123981	0.00001948	
139234	9.57081048	
139688	138.771584	

DAS 27
6 9-89 DAS 27
9-89 9-89

APR 12 2016

APR 18 2016

DART AEROSPACE LTD.

IIN-D412-709

Page 12 of 12

5.0 PARTS LIST

DAS
28
2-89

Qty -011	Qty -013	Qty -015	Qty -017	Qty -019	Qty -021	Qty -023	Part Number	Description
X							D412-709-011	ESCAPE PANEL MODIFICATION KIT
1	X						D412-709-013	ESCAPE PANEL PUSH OUT WINDOW KIT
		X					D412-709-015	HINGE PANEL DOOR MODIFICATION KIT
		1	X				D412-709-017	HINGE PANEL DOOR REPLACEMENT WINDOW KIT
				X			D412-709-019	CARGO DOOR PUSH OUT WINDOW KIT
					X		D412-709-021	HINGE PANEL DOOR PUSH OUT WINDOW MODIFICATION KIT
					1	X	D412-709-023	HINGE PANEL DOOR REPLACEMENT PUSH OUT WINDOW KIT
			1				D2126-0720	LOCKING SEAL
1				1			D3118-3	SIGN ASSEMBLY
	1						D3136-041	WINDOW ASSEMBLY
							D3136-043	WINDOW ASSEMBLY
1							D3224-1	FRAME
			1				D3236-1	WINDOW
						1	D3237-1-0720	SEAL RETAINER
	1			1			D3237-1-0980	SEAL RETAINER
						1	D3237-3-0720	SEAL FILLER
	1			1			D3237-3-0980	SEAL FILLER
2							D3239-1	COVER
		1					D3240-1	FRAME
						1	D3543-1	HINGE PANEL DOOR PUSH OUT WINDOW
					1		D3543-3	HINGE PANEL DOOR PUSH OUT WINDOW FRAME
	1			1		1	D3561-1	WINDOW SEAL TOOL
3							AN6-20A	BOLT
2							AN960JD10L	WASHER
5							AN960JD616	WASHER
5							AN960JD616L	WASHER
2							MS21042L3	NUT
3							MS21042L6	NUT
2							MS35207-262	SCREW